[0028]
During the manufacture of battery of the above constitution, along with the manufacture of the electrode plate group 3, the negative electrode collector plate 5 is connected by welding onto the end surface on which the negative electrode core material is exposed, and this electrode plate group 3 is accommodated by inserting it in the outer case 2, with the negative electrode collector plate 5 attached to the bottom of the outer case 2 by resistance welding. Thereupon gasket 12 is fitted in the internal circumference of the opening of the outer case 2; then the part 6, in the form of a small-diameter tube with a bottom, of the cover 4 is fitted into the opening part of the outer case 2 and pushed towards the electrode plate group 3; in this condition, having treated the immobilizing channel 13 by caulking from the external surface of the opening part of the outer case 2 the outer case 2 and the cover 4 are immobilized through gasket 12 in a state where their electrical insulation and sealing properties guaranteed. In this state, the protruding part 4a of the cover 4 adheres to the end surface on which the positive electrode core material of the electrode plate group 3 is exposed, while on the outer surface side the protruding part 4a is attached by welding to the positive electrode core material by means of laser beam welding etc. Thereupon a predetermined amount of electrolyte is injected through the injection port 9 of the cover 4. Once the electrode plate group 3 has been impregnated, the battery 1 is completed by sealing the injection port 9 with the sealing means 10.